

Date: Monday, 6/25/2007 9:11:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 33124		
Estimate Number	: 11403		
P.O. Number	: <i>N/A</i>	Part Number	: D3296041
This Issue	: 6/25/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3296 REV A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 32288	Material	: <i>N/A</i>
Written By	:	Due Date	: 7/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est. C 06/10/14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch	
1	D3296-1	Door Panel	<u>B33125</u>	X20

*ml*

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch	
1	D3296-3 Door	Panel	<u>B33126</u>	X20

*ml*

3.0	D31617	Hinge 14"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Hinge 14"

Batch: B32732 X6 B33190 X14*ml*

4.0	D31619	Hinge 17"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Hinge 17"

Batch: B33191 X20*ml 07/08/07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: DOOR ASSEMBLY

Job Number: 33124

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 500.0000 Each(s)

Rivet, Universal Head

Batch: M105125

✓ ml 07/08/07

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

ml 07/08/07 (x20)

PTO

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counted  
cr 07/08/08 (x70)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 102 B/K

BR/ML 07-08-13

(20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/08/01

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal 32198

4 50  
24358

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch


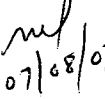



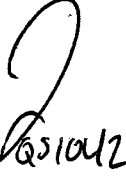
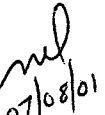

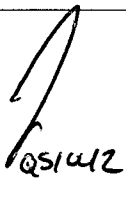

1 D2419 Handle 31331

4 8  
32354 33186

7/8/04 SG

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/08/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/01	6	Scrap one D3161-7 more during make holes (drilling)		Scrap one and replace by new one B33190	 07/08/01	 07/08/07		 07/08/07
07/08/08	6	one bad rivet  R.C. Hummer Error		Took out and replace by new one B105125	 07/08/01	 07/08/08		 07/08/08

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 33124

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

1329456

59

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

1329456

50

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 Seal

1329456

50

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

24215

50

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

146085

50  
7/8/77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

*M104118*

*SE 7/8/14*

*(P40)*

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

*M 07/08/20*

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counter*  
*En 07/08/23 (x20)*

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*272A*

*in 07-08-24*

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(20)*  
*07/08/27*

Job Completion



*in 07-08-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0708-21	19.0	Two large scratches were found at final AS inspection.	OS1012	Disassemble tab: remove labels 320 grit paper. buff out marks in affected area. Sand smooth with 320 grit paper. Touch-up area with Alodine per QS1005.	ml 07/08/21	EP 07/08/23	OS1012	EP 07/08/21
0708-4	19.0	"	OS1012	* Verify by Q.C. *	CP 07/08/21			
			OS1012	Powder coat per QS1005	FF 07/08/23			
			OS1012	Re-install		CP 07/08/23	OS1012	EP 07/08/21
07/08/21	19.0	"	↓	Scrap one MS20470-AD4-4 replaced → M105125 Scrap one D2137 replace → B31463 Scrap one D2728-1 replace → B31435 Scrap one MS20470-AD4-6 replace → M104418 Scrap one seal D2462-0040 -0053 -0045 → replace → M29456	ml 07/08/22	↓	↓	↓

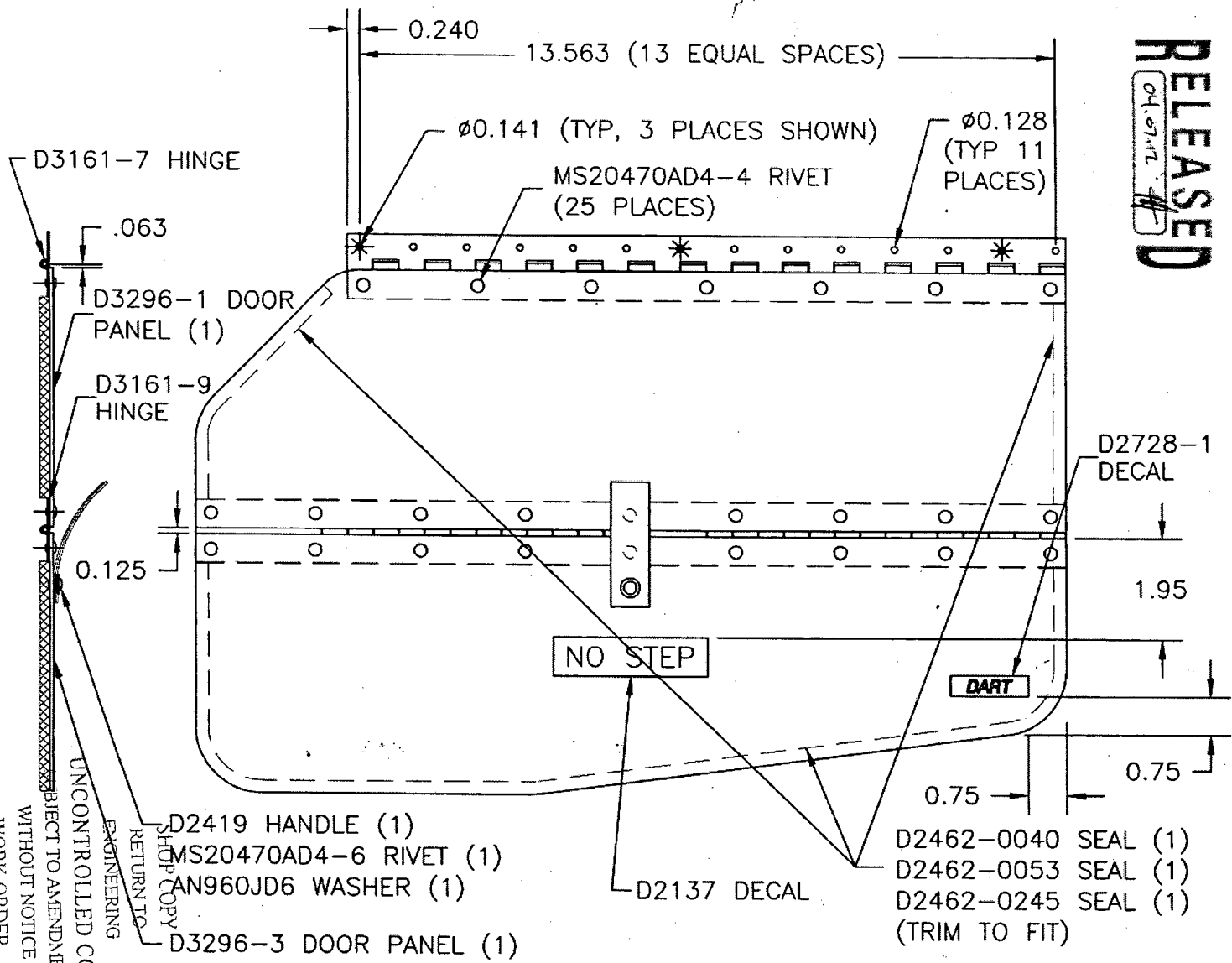
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DATE		TITLE	1 OF 2
04.06.28		DOOR ASSEMBLY	SCALE
A	04.06.28	NEW ISSUE	1:3

RELEASED  
04.07.12



**D3296-041 DOOR ASSEMBLY**

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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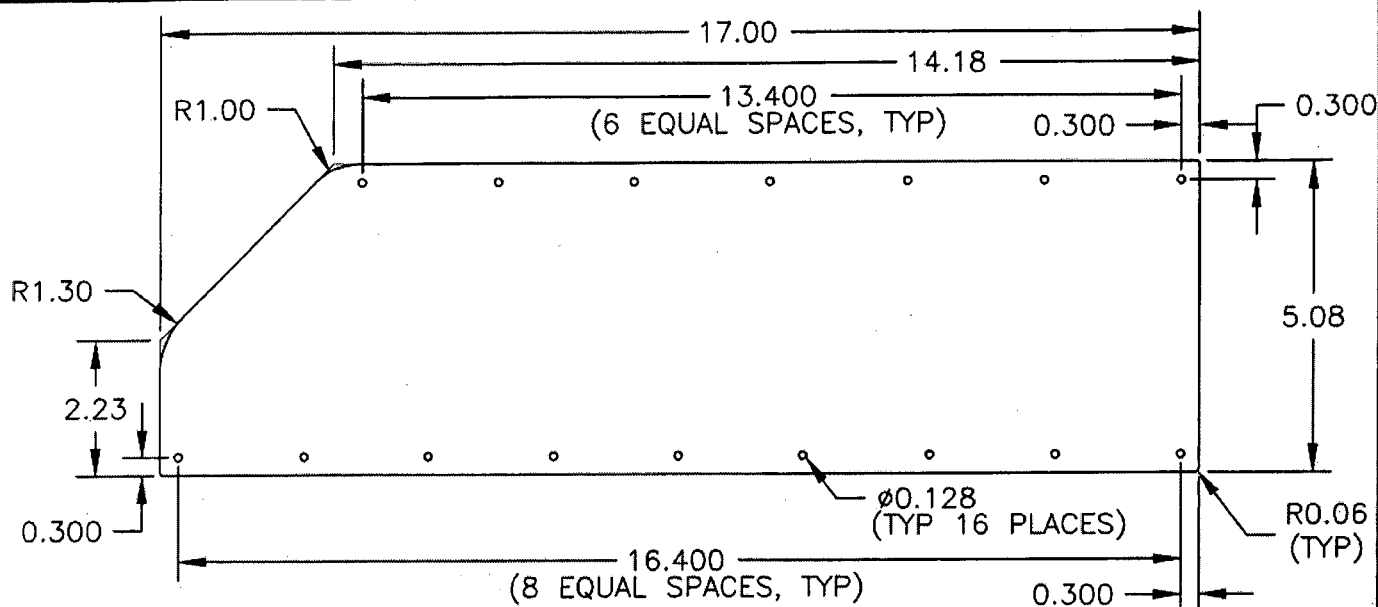
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WORK ORDER

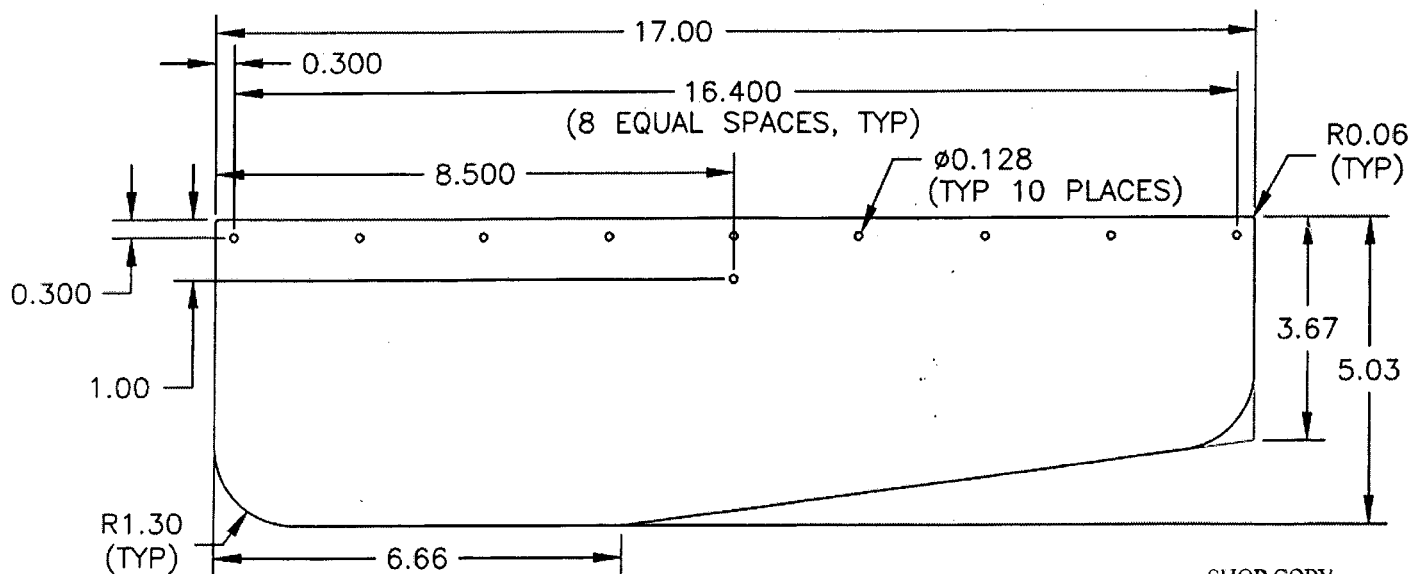
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DATE 04.06.28	TITLE DOOR ASSEMBLY		SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

**D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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